



Dart Aerospace Ltd.
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Canada

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D2344
Job Sheet 192162



Part No: D2344

Job Qty: 1 pcs

Part Name: Deck Plate Aft



Part Weight: 0 lbs

Job Created: 3/18/19

Due Date: 3/22/19

Type: SOLD

Status: New

Priority: Medium

Job Tracking No:

Created By: Linda Lacelle

Description:

Note: DWG REV F IPP Rev:D 00.06.26 Removed P/O for powder coat EC IPP Rev:E 07-07-04 Asper Rev F JLM
Ship Via: *per DSI 9785 - No Holes*

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	1		3/22/19	0.11	0.16	Waterjet - Flow		<i>OK 19/03/19</i>
		pcs							
120	QC 8	1		3/22/19	0.00	0.00	QC 8 - 12		
		pcs					QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
130	Small Fab - 2 - B4B	1		3/22/19	0.00	0.13	Small Fab - 1 - B4B		
		pcs					Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		

140 QC 5	1 pcs	3/22/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
150 Handfinish - 1-1 Chemical- B4B	1 pcs	3/22/19	0.00 0.06	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
155 QC 7	1 pcs	3/22/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	

MAR 20 2019
 FEB 19-03-28
 DAS
 40
 9:39

					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
160	Powdercoat - 4 Black Sand - B4B	1 pcs	3/22/19	0.00 0.04	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
170	QC 3	1 pcs	3/22/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
180	Packaging 3-1 - Stock - B4B	1 pcs	3/22/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	Starts A 01 MAR 21 2019
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	

				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	1	3/22/19	0.00 0.00	QC 21 - SA - 21	DAG
	pcs			QC 21 - SA - 70	21
				QC 21 - SA - 53	5-01 MAR 21 2019

Part Op **100** - 1-Cut as per dwg prog rev: F dwg rev: F
 Descriptions: **120** - (QC8- Inspect parts - second check)
130 - (Small Fab) 1-Deburr sharp edges 2-Countersink holes per Dwg D2344
140 - (QC5- Inspect part completeness to step on W/O)
150 - (Chemical Conversion Coat per QSI005 4.1)
155 - (QC7-Inspect Chemical Conversion Coat)
160 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____
170 - (QC3- Inspect Part Finish)
180 - (Identify as per dwg & Stock Location: _____)
190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	.7450 sf (.745 ea)	100-Waterjet - Flow - 1	5141235

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.063	1	66	0

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-616 REV. F OR LATER APPROVED REVISION

REF. TCCA STC: SH96-10
REF. FAA STC: SR00405NY
REF. EASA STC: 10042994
REF. ANAC STC: 2013S02-03
REF. DGAC STC: 84-SI0995
REF. DANISH STC: 27/96

1.0 PURPOSE

The purpose of this DART Service Instruction (DSI) is to clarify the installation instructions related to the D2344 Litter Deck Plate, which is part of the DART D350-616-011 Emergency Litter Kit and to provide instructions on how to install the D2344 Custom Aft Deck Plate, which does not include pre-drilled holes. This allows the customer to transfer drill existing holes from the aircraft into the Custom Aft Deck Plate.

2.0 INSTALLATION

In addition to the instructions provided in IIN-D350-616 and D350-616, the D2344 Custom Aft Deck Plate is to be installed onto the aircraft as follows:

- 1) Locate the D2344 Custom Aft Deck Plate on the aircraft per Figure 1 of this service instruction.
- 2) Transfer drill all holes and profiles from the aircraft to the custom aft deck plate per Figure 1 of this service instruction. Maintain a minimum edge distance of 2D and a minimum pitch of 3D.
- 3) Countersink all $\varnothing 0.128$ hole to $\varnothing 0.225 \times 100^\circ$, all $\varnothing 0.171$ holes to $\varnothing 0.285 \times 100^\circ$, and all $\varnothing 0.191$ holes to $\varnothing 0.351 \times 100^\circ$. Deburr all holes.
- 4) Touch up with chemical conversion coating per MIL-C-5541, one coat of MIL-P-85582 or MIL-P-23377 primer, and 2-3 coats of MIL-C-85285 polyurethane coating to match original finish.
- 5) Fasten the Custom Aft Deck Plate to the aircraft floor per IIN-D350-616.
- 6) Complete D350-616-011 Kit installation per IIN-D350-616.
- 7) Ensure that the D2370-1 Litter Assembly can be installed and secured by the litter tie downs and that it does not interfere with any aircraft controls.
- 8) Update the aircraft logbook to indicate installation of D2344 Custom Aft Deck Plate as part of the D350-616-011 Litter Kit.

3.0 WEIGHT AND BALANCE

There is a negligible weight and balance change associated with the D2344 Custom Aft Deck Plate installation.

4.0 MAINTENANCE

Maintain installation per ICA-D350-616.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO #01-O-01

APPROVED

BY: 
C. PROVENCAL (DE # 03)

DATE: 17.07.07
CERT. NO.: SH96-10
ISSUE NO.: 3

APPROVED

A	NEW ISSUE	ML	17.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9785	SHEET 1 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	CP	CUSTOM AFT DECK PLATE	NTS
DATE	17.07.07	COPYRIGHT © 2017 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

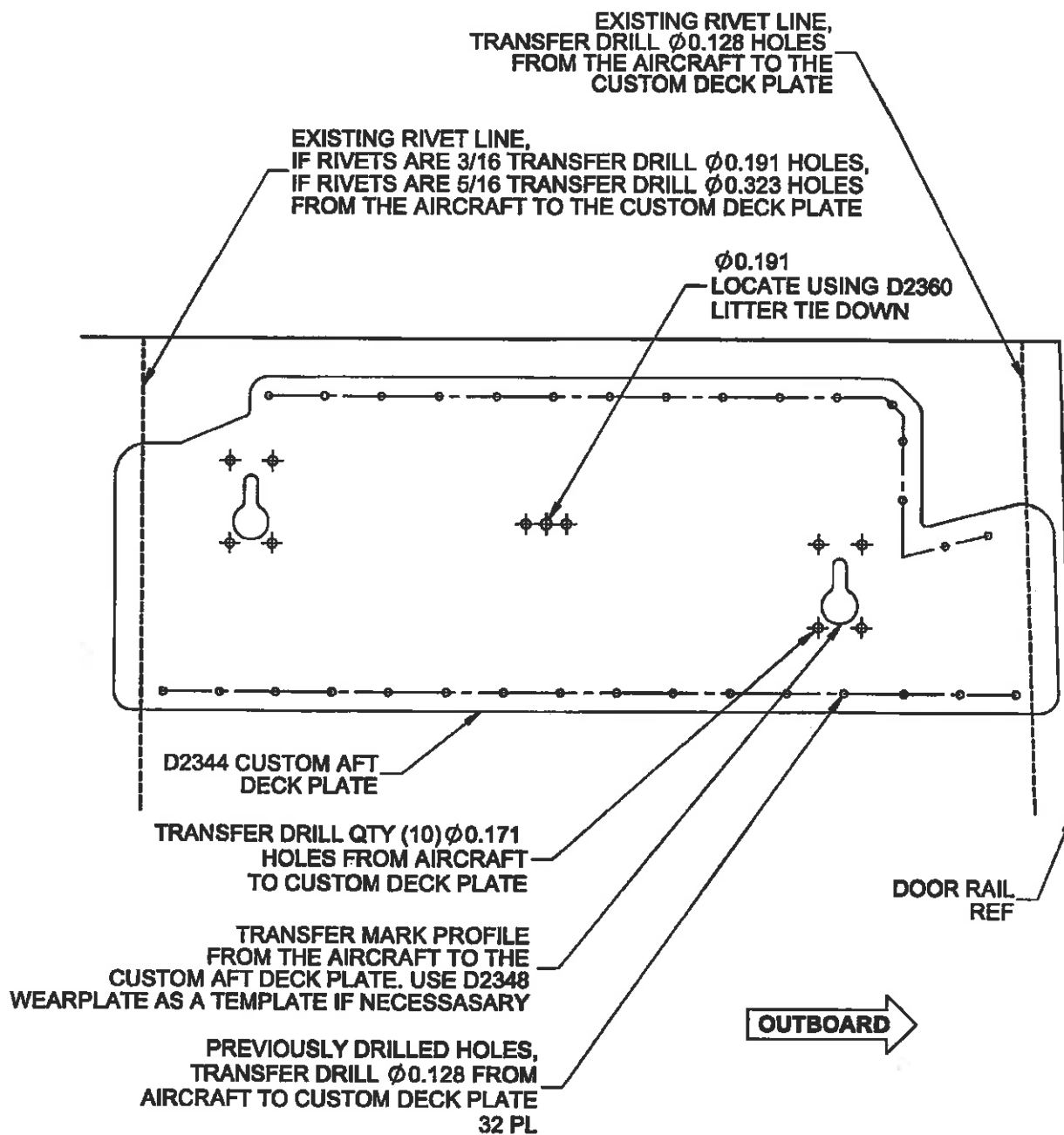


FIGURE 1: D2344 CUSTOM DECK PLATE INSTALLATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *C. Provencal*
C. PROVENCAL (DE # 03)

DATE: 17.07.07
CERT. NO.: SH96-10
ISSUE NO.: 3

APPROVED

DESIGN	ML
DRAWN	ML
CHECKED	AJS
MFG. APPR.	N/A
APPROVED	WM
DE APPR.	CP
DATE	17.07.07

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A
DSI 9785 SHEET 2 OF 2
TITLE SCALE
CUSTOM AFT DECK PLATE NTS

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Container No: S163698



Part: D2344

Job No: 192162

Serial No/Batch: S163698

Revision:

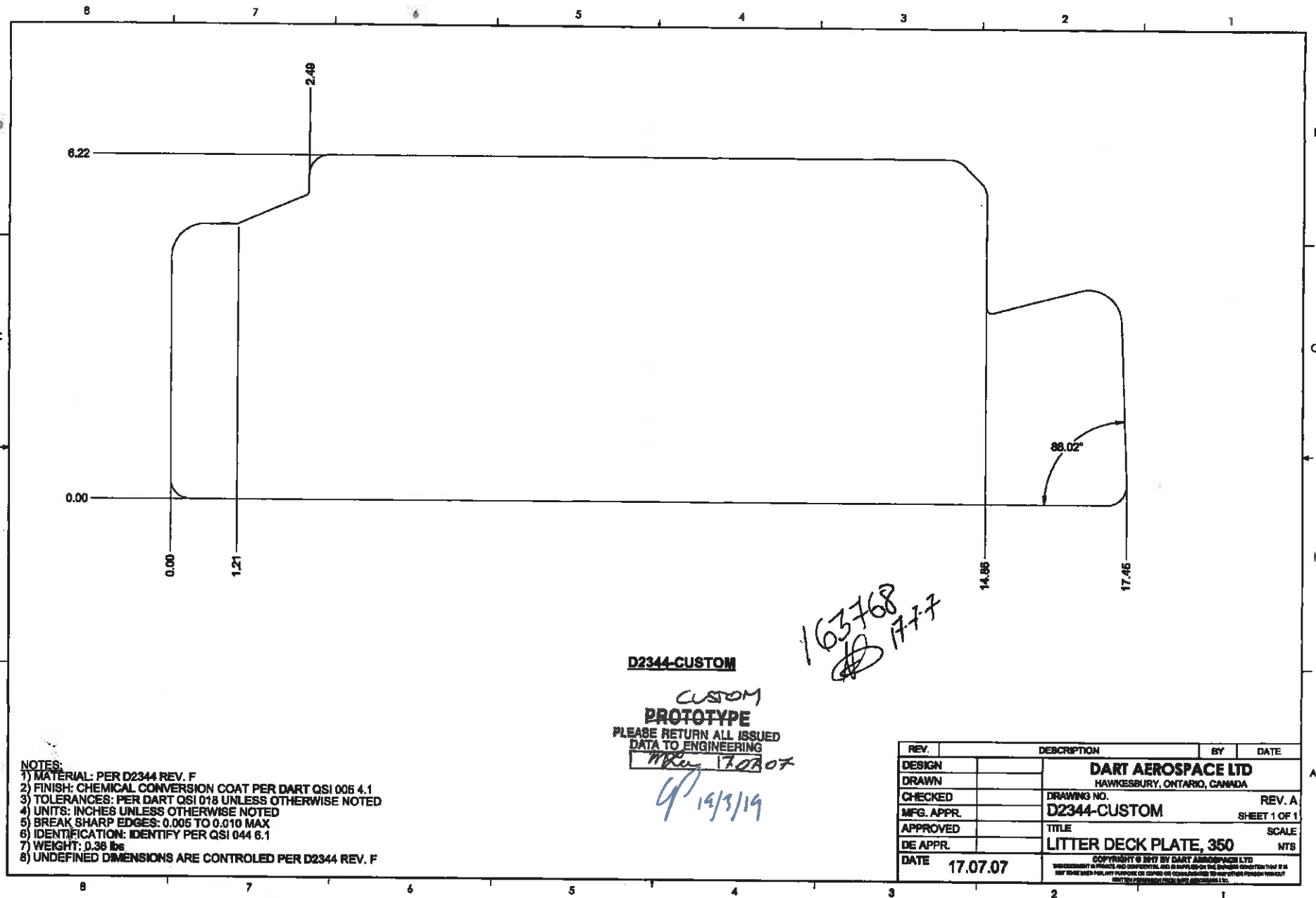
Inspector:

Exp Date:

Instructions: Various STC's

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Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 832-6200
Email: sales@dartaero.com
www.dartaero.com

Date: 03/10/19



- NOTES:
- 1) MATERIAL: PER D2344 REV. F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.38 lbs
 - 8) UNDEFINED DIMENSIONS ARE CONTROLLED PER D2344 REV. F

D2344-CUSTOM
CUSTOM
PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
163768
17-7
19/3/19

REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	17.07.07		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2344-CUSTOM	REV. A
TITLE LITTER DECK PLATE, 350	SCALE NTS
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TR

Oct 24/19.



NCR No.

19-7551

Route update only

Job: 192162		DISPOSITION		DEPARTMENT/PROCESS			
Part No. D2344		Rework ☒ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐
Date: 19/3/19		Sequence #: 170		QTY Affected: 1		MRB (QSI042) INSP 12 19/3/19	
Description Work Order Deviation				Disposition			
Customer requires custom deck plate without holes.				Acceptable to manufacture per DS19785 & attached reference dwg. Ship part with DS19785 Rev.A. No powder coat. Part is identical to D2344 Rev F except lack of holes and width is 17.45"			
Completed By JL 19.07.19				Lead hand / Supervisor JL 19.07.19			
QC / QA Coordinator DAS 55 9-89 31 JUL 2019							
Root Cause		FAULT CATEGORY					
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☒ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
		Other/Details:					